

Date: Thursday, 5/25/2006 11:33:14 AM
 Ser: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LABEL PLATE
Job Number	: 27217		
Estimate Number	: 10599		
P.O. Number	: N/A	Part Number	: D2506
This Issue	: 5/25/2006 S.O. No. : N/A	Drawing Number	: D2506 REV D1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: D1
Previous Run	: 27217	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 6/1/2006
Checked & Approved By	:	Qty:	25 Um: Each
Comment	: Est. B 01.06.08 Now laser cut EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 1.2810 sf(s)/Unit Total: 32.0250 sf(s)

304/316 .040 Sheet

Batch: M19093 n1101264

MM 06 06 01

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D

Dwg Rev: 01

Prog Rev: 01

MM 06 06 12

(25)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MM 06 06 12

(25)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

MM 06 06 13 25

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

SAD 06:06:14

(25)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *LD* Date: 06/07/04

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 5/25/2006 11:33:14 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LABEL PLATE

Job Number: 27217

Part Number: D2506

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per dwg D2506

SB 06/07/20 (25)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-07-20 (25)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

06-07-20 (25)

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06-07-21

Job Completion



W 06-07-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 11:36:11 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LABEL PLATE
Job Number	: 27217		
Estimate Number	: 10599		
P.O. Number	:	Part Number	: D2506
This Issue	: 5/23/2006	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2506 REV D1
First Issue	: / /	Project Number	: N/A
Previous Run	: 26631	Drawing Revision	: D1
	Type	Material	:
	: PURCHASED PARTS	Due Date	: 6/15/2006
Written By	:	Qty:	25
Checked & Approved By	:	Um:	Each
Comment	: Est. 01.06.08 Now laser cut EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 1312

Laser Cut per Dwg D2506

Material: AISI 304/316 SS 20 gauge (0.040" thick)

Material release note required

06/05/23
 25

2.0	D2506F	Placard
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 25.0000 Each(s)
 Placard

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Debur

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 11:36:11 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LABEL PLATE

Job Number: 27217

Part Number: D2506

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per dwg D2506

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

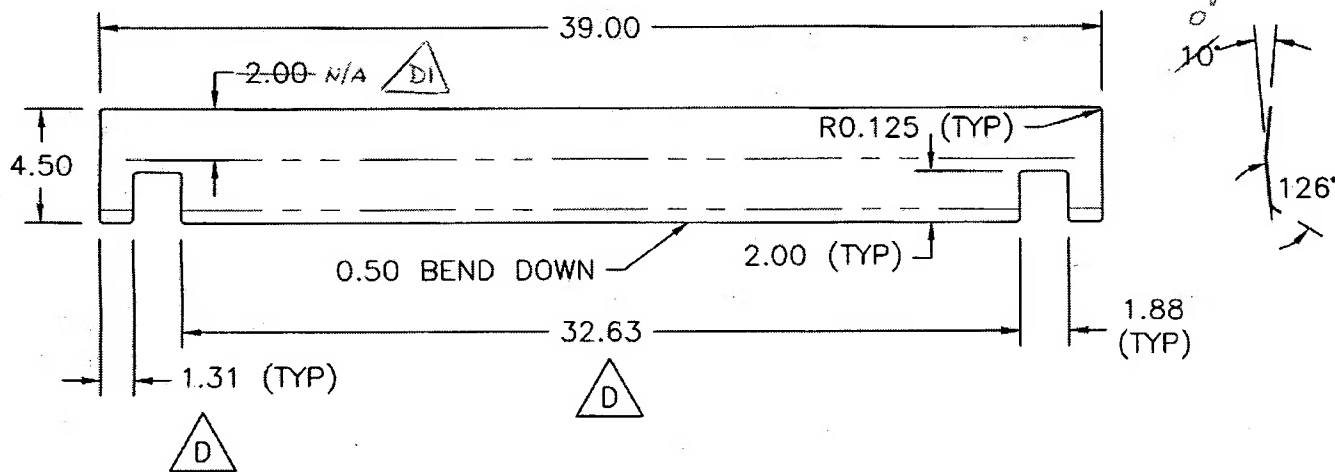
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DA COPY 1981117

99.10.12 KE

DESIGN	BW	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	11	APPROVED	D2506	REV. 0
DATE	99.10.04	TITLE	LABEL PLATE	SHEET 1 OF 1
B			REDESIGN OF LABEL PLATE	SCALE 1:7
C			REDESIGN OF LABEL PLATE	
D			32.63 WAS 32.25, 1.31 WAS 1.50	
D1	11	04.06.23	0° WAS 10°	



D2506 FLAT PATTERN

NOTE: USE R0.08 BEND RADIUS

MATERIAL: AISI 304/316 SS, 0.040 THICK (20 GAUGE)

20.10.04
20.10.04

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27217

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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